

# Work Order ID 55383

January 15, 2010 8:38:38 AM

Page 1

Item ID: D3774-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Seat Back, LH/RH

Start Date: 1/15/10 Start Qty: 20.00

Cust Item ID:

Required Date: 1/22/10 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan:

Date: 10-1-15

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3774

Rev 2

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Set up machine program D3774-3 Set up clamping frame as per folio

OK 10/01/15  
X 20

110



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

BB 10/01/15  
X 20

120



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D32811 and Folio FTA 011 Dwg. Rev.

Folio Rev. C

OK 10/01/15  
X 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

BB  
10/01/15  
X20

140

HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

BB  
10/01/15  
X20

150

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

1) Check dimensions to ensure conformity to drawing tolerances.

BB  
10/01/15  
X20

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Page 3

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Cust Item ID:

Required Date: 1/22/10 Req'd Qty: 20.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Tested each one couldn't get parts  
to crack S. Colours  
Memo

0.00

2) S. Colours

count  
(20) /

170

Identify as per dwg & Stock Location: 257

0.00

Packaging

Memo

0.00

Packaging

10-1-18 (200) SP

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/01/18  
MF 10-1-18

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**NOTE:** Date & initial all entries

# Picklist Print

January 15, 2010 8:38:42 AM

Page 1  
T

Work Order ID: 55383



Parent Item: D3774-3



Parent Item Name: Seat Back, LH/RH

Start Date: 1/15/10

Required Date: 1/22/10

Comments: IPP REV:A New Issue 08.06.04 DL verified by:DD  
IPP REV. B Dwg. Update 08.08.19 DL

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	1,299.650	213.3400			



GE PLASTICS LEXAN SHEET

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	1299.649998	
103106	1.6765	
105330	47.8767	
109455	40.5717	
111710	329.893632	
112585	879.631466	

BB  
12/01/15  
X20

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	55383
<b>Description:</b> Seat Back		<b>Part Number:</b>	D3774-3
<b>Inspection Dwg:</b> D3774 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				

Measured by: JB      Date: 10/01/17

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100	1.37	✓			
33.9	+/-0.100	33.9	✓			
0.085	Min	.0985	✓			
<del>0.100</del> .065	Min	.071	✓			
0.100	Min	.104				
0.100	Min	.114				
0.100	Min	.114				
0.100	Min	.118				
0.100	Min	.110				
0.100	Min	.112				
0.100	Min	.104				

Measured by: JB      Date: 10/01/17

Audited by: S      Date: 10/01/18

Prototype Approval: N/A      Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL	
B	09.05.19	Dimension 17.4 removed	KJ	

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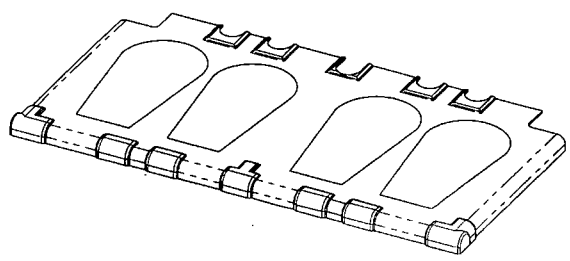
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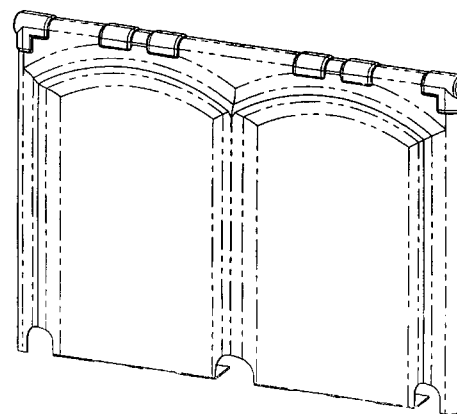
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RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 55383  
110-1-15



D3774-1 SEAT BOTTOM



D3774-3 SEAT BACK

**RELEASED**  
06-08-11/15

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES	PH	08.07.25
A	NEW ISSUE	HS	08.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3774</b> REV. B SHEET 1 OF 3 TITLE <b>SEAT</b> SCALE NTS DATE <b>08.07.25</b> <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DRAWN	PH		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		

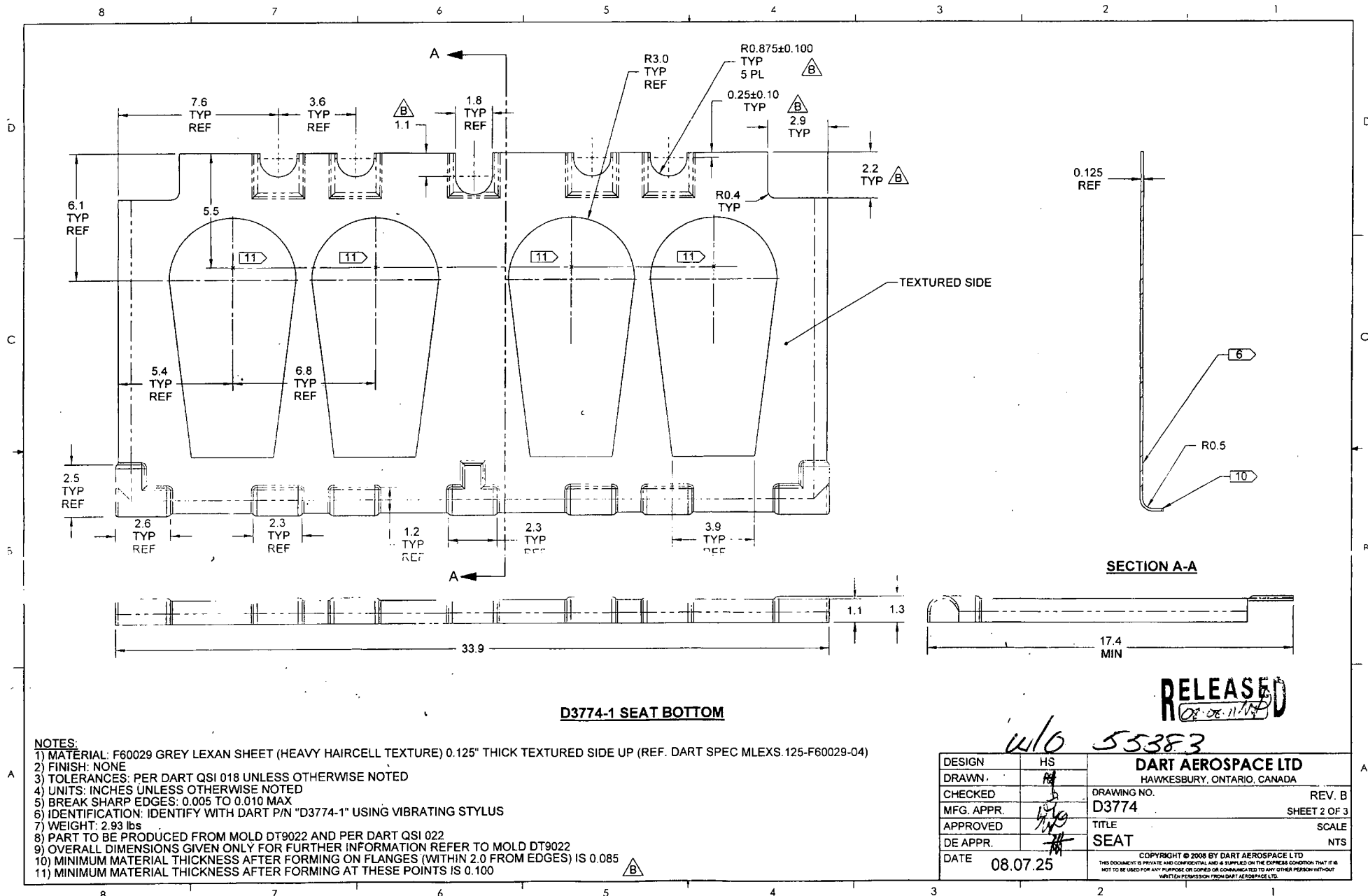
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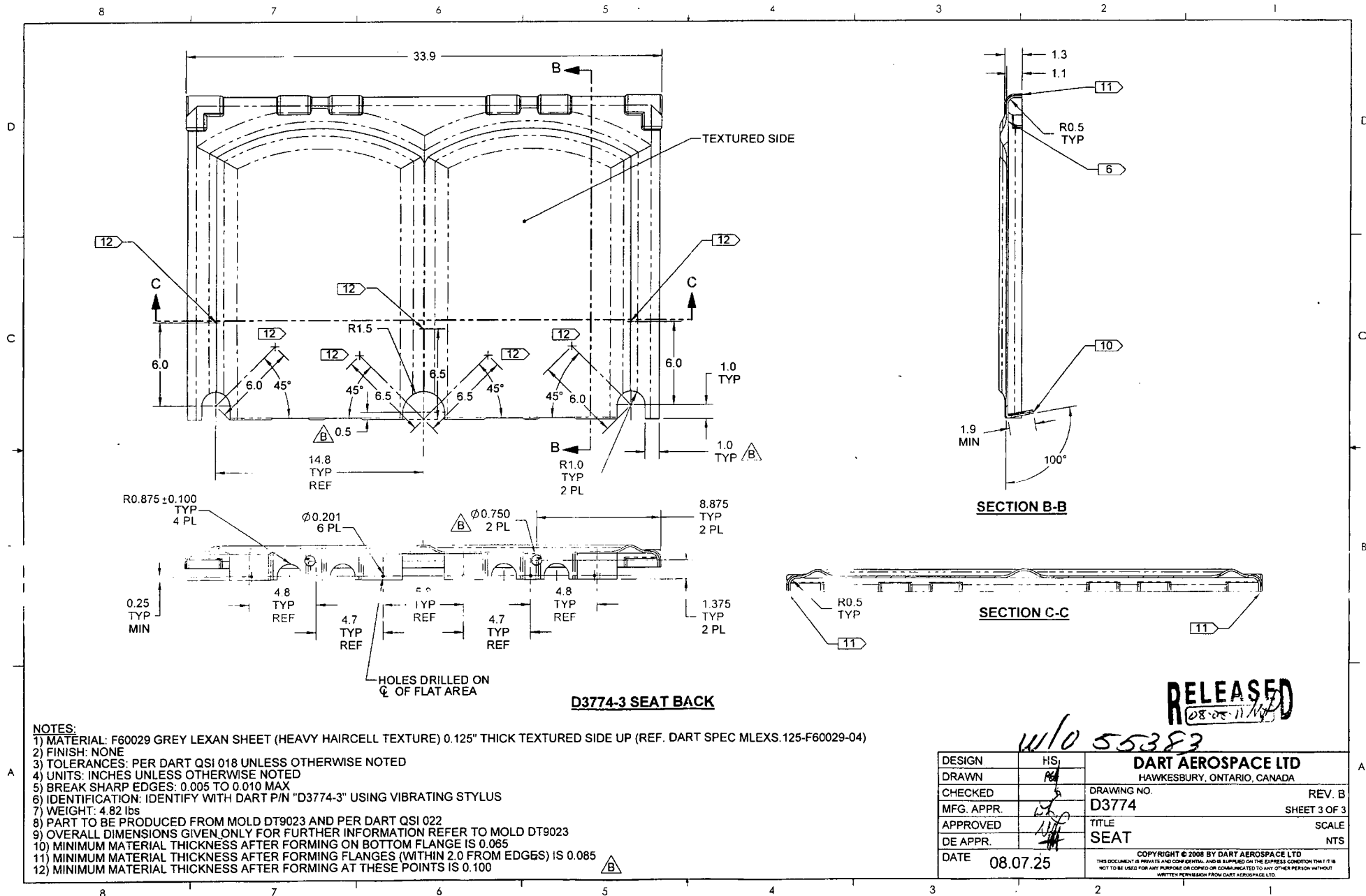
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**RELEASED**  
08-07-11

DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3774</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>SEAT</b>	NTS
DATE	08.07.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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